



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D5033-1**  
**Job Sheet 167126**



**Part No:** D5033-1

**Job Qty:** 384 ea

**Part Name:** Rigid Polyurethane Foam



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 10/25/17

**Job Tracking No:**

**Due Date:** 11/23/17

**Created By:** Chantal Lavoie

**Type:** Stock

**Description:**

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation  | Qty     | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           |
|-------|------------|---------|------------|----------|-----------|---------|-----------------------|-----------|
|       |            |         |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |
| 100   | Purchasing | 384 pcs |            | 11/23/17 | 0.00      | 0.00    | Purchasing            | SP 12-4   |
| 110   | Packaging  | 384 pcs |            | 11/23/17 | 0.00      | 0.00    | Packaging2            | SP 12-4   |
| 120   | QC         | 384 pcs |            | 11/23/17 | 0.00      | 0.00    | QC6                   | 38        |
| 130   | Packaging  | 384 pcs |            | 11/23/17 | 0.00      | 0.00    | Packaging3            | 9-89      |
| 140   | QC21-SA    | 384 Ea  |            | 11/23/17 | 0.00      | 0.00    | QC21                  | MFO20     |

Part Op 100 - Issue P/O: \_\_\_\_\_ Vendor: ACP COMPOSITES Vendor Part#: LP-06D 1/8"  
Descriptions: 110 - Ensure material release note is attached  
130 - LOCATION: MAT020

DEC 05 2017

### Job Allocations

| Operation      | Component Part | Required | Inventory | Allocated | Std Qty |
|----------------|----------------|----------|-----------|-----------|---------|
| 100-Purchasing | LP-FC125-FG1-9 | 384      | 0         | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 10/25/17 7:28 AM dart.lavoie.chantal

**DART**  
AEROSPACE  
**S017018**

**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K64 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com



**Rigid Polyurethane Foam**

**PART NO: D5033-1**

**Revision:**

**Operation:**

**Change No:**

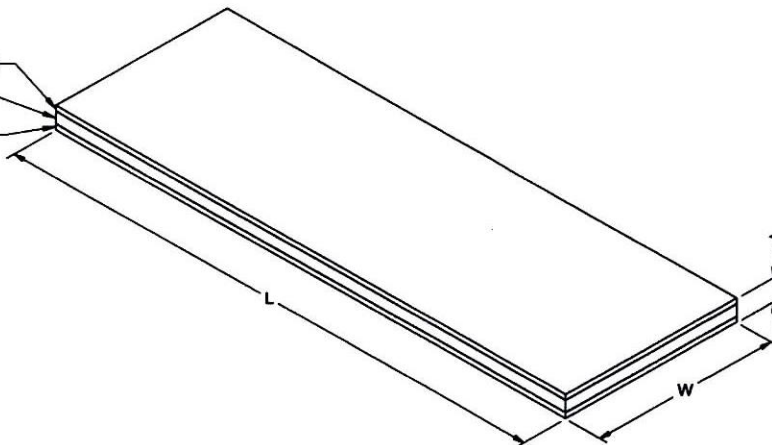
**Purchasing - SF**

**Mfg Date: 12/04/17**

**Job No: 167126**

# SPECIFICATION CONTROL DRAWING

AX-3110 FIBERGLASS 1 PLY LAYER  
FR3706 POLYURETHANE FOAM  
AX-3110 FIBERGLASS 1 PLY LAYER



DAS  
13  
9-89

OCT 25 2017

W10: 167126

D5033-X



| DART<br>PART NUMBER | DESCRIPTION             | POSSIBLE<br>VENDOR | VENDOR<br>PART NUMBER | MATERIAL   | W  | L  | T     | WEIGHT<br>(lbs) |
|---------------------|-------------------------|--------------------|-----------------------|------------|----|----|-------|-----------------|
| D5033-1             | RIGID POLYURETHANE FOAM | ACP COMPOSITES     | LP-FC125-FG1-9        | PER FIGURE | 48 | 96 | 0.125 | 1.97            |
|                     |                         |                    |                       |            |    |    |       |                 |

## NOTES:

- 1) MATERIAL: PER FIGURE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5033-X" & DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: SEE TABLE

**RELEASED**

2015 JAN 26  
ECN 14-634

APPROVED

| B          | LP-FC125-FG1-9 WAS LP-06D 1/8" (ZN B5-1) | RF                                                                                                                                                                                                                                                                  | 14.11.28     |
|------------|------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A          | NEW ISSUE                                | RF                                                                                                                                                                                                                                                                  | 13.12.09     |
| REV.       | DESCRIPTION                              | BY                                                                                                                                                                                                                                                                  | DATE         |
| DESIGN     | RF                                       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                            |              |
| DRAWN      | RF                                       |                                                                                                                                                                                                                                                                     |              |
| CHECKED    | VS                                       | DRAWING NO.                                                                                                                                                                                                                                                         | REV. B       |
| MFG. APPR. | JLM                                      | <b>D5033</b>                                                                                                                                                                                                                                                        | SHEET 1 OF 1 |
| APPROVED   | HS                                       | TITLE                                                                                                                                                                                                                                                               | SCALE        |
| DE APPR.   | DS                                       | <b>FOAM CORE</b>                                                                                                                                                                                                                                                    | NTS          |
| DATE       | 14.11.28                                 | COPYRIGHT © 2013 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD |              |





Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER PO038142

**Supplier:** ACP001-VU  
ACP Composites  
78 Lindbergh Ave,  
Livermore, CA 94551 USA  
Phone: 925-443-5900  
Fax: 925-443-5900

**PO No:** PO038142

**PO Date:** 10/25/17

**Due Date:** 11/20/17

**Purchase Order**

**Revision:**

**Revision Date:**

**Ship-To Contact:** Phone:

**E-MAILED**  
10/25/17

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground

**Pymt Terms:** COD

**Freight Terms:**

**Special Comments:**

| Items                       |                |     |                  |         |                                                                  |          |        |          |                |                   |         |                         |                |
|-----------------------------|----------------|-----|------------------|---------|------------------------------------------------------------------|----------|--------|----------|----------------|-------------------|---------|-------------------------|----------------|
| Line Item                   | Part           | Rev | Supplier Part No | Item No | Description                                                      | Item Tax | Status | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (USD)        | Extended Price |
| 1                           | LP-FC125-FG1-9 |     |                  |         | Fiberglass 1 Ply/Foam Panel 125"x48"x96" As per Dwg D5033 Rev. B |          | Firmed | 11/13/17 | 320 sf         | 0 sf              | 320 sf  | \$14.1172/sf            | \$4,517.50     |
| Line Item Note Job # 167125 |                |     |                  |         |                                                                  |          |        |          |                |                   |         |                         |                |
| 2                           | LP-FC125-FG1-9 |     |                  |         | Fiberglass 1 Ply/Foam Panel 125"x48"x96" As Per Dwg D5033 Rev. B |          | Firmed | 11/20/17 | 384 sf         | 0 sf              | 384 sf  | \$14.1172/sf            | \$5,421.00     |
| Line Item Note job# 167126  |                |     |                  |         |                                                                  |          |        |          |                |                   |         |                         |                |
|                             |                |     |                  |         |                                                                  |          |        |          |                |                   |         | Grand Total: \$9,938.51 |                |

## Order Notes

Procurement Quality Clauses  
A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)  
A026 certification of material conformance  
A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

*[Signature]*  
J.B.

Plex 10/25/17 9:00 AM dart.baker.diane



ACP Composites, Inc  
78 Lindbergh Ave.  
Livermore CA 94551  
United States  
(925) 443-5900  
www.acpsales.com

## Packing Slip # 12095

|            |                    |
|------------|--------------------|
| Order #    | 88584              |
| Order Date | 10/25/2017         |
| PO #       | PO038142           |
| Ship Date  | 11/17/2017         |
| Ship Via   | Freight Economy    |
| Tracking # | ForwardAir60638457 |

### Ship To

Chantal Lavoie  
Dart Aerospace Ltd.  
1270 Aberdeen  
Hawkesbury ON K6A 1K7  
Canada

| Line | Item           | Description                                                                                                                                                 | Units | Ordered | Shipped | Inventory Detail |
|------|----------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------|-------|---------|---------|------------------|
| 1    | LP-FC125-FG1-9 | .125" x 48" x 96"<br>6PCF Foam Core, 1 Ply Fiberglass<br>Panel<br>.141" +/- 15% Thickness Tolerance<br>+/- .250" L/W Tolerance<br>Freight Shipping Required | Ea    | 10      | 10      | Ware-R9(10)      |
| 2    | LP-FC125-FG1-9 | .125" x 48" x 96"<br>6PCF Foam Core, 1 Ply Fiberglass<br>Panel<br>.141" +/- 15% Thickness Tolerance<br>+/- .250" L/W Tolerance<br>Freight Shipping Required | Ea    | 12      | 12      | Ware-R9(12)      |
|      | *ADDHAN-C      | Additional Handling Required                                                                                                                                | Ea    | 1       | 1       |                  |
|      | *CERT-STANDARD | Standard Certificate of Conformance<br>Required<br>This is for both Lines # 1 and 2                                                                         |       | 2       | 2       |                  |



88584

# Commercial Invoice

**Shipper/Exporter**

ACP COMPOSITES  
78 LINDBERGH AVENUE  
LIVERMORE, CA 94551 USA  
(925)443-5900

**Date**

20-November-2017

**Invoice No.**

88584/12095

**Customer PO No.**

PO038142

**Currency Used**

USD

**Country of Origin**

USA

**B/L / AWB No.**

Forward Air 60638457

**Consignee**

Chantal Lavoie  
Dart Aerospace Ltd.  
1270 Aberdeen  
Hawkesbury ON K6A 1K7  
Canada  
(613) 632-5200

**Final Destination**

Canada

**Export Route / Carrier**

---

**Terms of Sale**

FOB

**Terms of Payment**

Net30

**Terms of Freight**

---

**No. of Packages**

1

**Intermediate Consignee****Notes****Item & Description****HS No.****Unit Value****Quantity****Weight: Lbs.****Value**

Fiberglass / Foam Panels, .125" x 48" x 96" 7019190000 \$451.75 22 200 \$9938.50

**Sub Totals 22 200.00 \$9938.50**

**Freight \$0**

**Insurance \$0**

**Total Value \$9938.50**

*88584-4*

I hereby certify this commercial invoice to be true and correct.

Shipper 

Title *SHIPPER*

Date *11/20/17*



## Certificate of Conformance

QP-22-03F

Revision: B

Date: August 18, 2015.

### RETAIL CERTIFICATE OF CONFORMANCE - STANDARD

Customer: Dart Aerospace Ltd.

Part #: LP-FC125-FG1-9

Description: .125" x 48" x 96" 6PCF Foam Core, 1 Ply Fiberglass Panel

Quantity Shipped: 10 ( First Shipment )

Order #:PO038142 /SO 88584

It is hereby certified that the materials detailed above conform to the current ACP or manufacturer's datasheet or specifications, PO requirements (if applicable) and are in conformance with ACP Composites' quality standards.

If you have any questions, please contact us at (925) 443-5900.

A handwritten signature in black ink, appearing to read "Jessica Sparr", is written over a large, faint, stylized watermark of the letters "ACP" in the background.

Jessica Sparr  
Vice President  
jrsparr@acpsales.com



## MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D5033-1 (6 PCF Foam Core) / BATCH NO.: 38142 / 5088584  
 DATE: 17-12-04 5017018

|                                       |                                 |
|---------------------------------------|---------------------------------|
| MATERIAL CERT REC'D: <u>Yes</u>       | THICKNESS ORDERED: <u>.125</u>  |
| QUANTITY RECEIVED: <u>12 x 4 x 8</u>  | THICKNESS RECEIVED: <u>.125</u> |
| QUANTITY INSPECTED: <u>12 x 4 x 8</u> | SHEET SIZE ORDERED: <u>4x8</u>  |
| QUANTITY REJECTED: <u>0</u>           | SHEET SIZE RECEIVED: <u>4x8</u> |

| DESCRIPTION                                     | NCR<br>(Check Y/N)                    |                                       | COMMENTS              |
|-------------------------------------------------|---------------------------------------|---------------------------------------|-----------------------|
| SURFACE DAMAGE                                  | Y                                     | <input checked="" type="checkbox"/> N |                       |
| CORRECT FINISH                                  | <input checked="" type="checkbox"/> Y | N                                     |                       |
| CORROSION                                       | Y                                     | <input checked="" type="checkbox"/> N |                       |
| CORRECT GRAIN DIRECTION                         | <input checked="" type="checkbox"/> Y | N                                     |                       |
| CORRECT MATERIAL PER M-DRAWING                  | <input checked="" type="checkbox"/> Y | N                                     | <u>LP-FC125-FG1-9</u> |
| CORRECT THICKNESS                               | <input checked="" type="checkbox"/> Y | N                                     |                       |
| PHOTO REQUIRED                                  | Y                                     | <input checked="" type="checkbox"/> N |                       |
| CORRECT REF # TO LINK CERT                      | <input checked="" type="checkbox"/> Y | N                                     |                       |
| CORRECT MATERIAL IDENTIFICATION                 | <input checked="" type="checkbox"/> Y | N                                     | <u>HTS P038142</u>    |
| CORRECT M# ON THE MATERIAL                      | <input checked="" type="checkbox"/> Y | N                                     |                       |
| DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF | Y                                     | N                                     |                       |
| DOES THIS REQUIRE AN EXTRUSION REPORT           | Y                                     | N                                     |                       |

| CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK.<br>RECORD RESULTS BELOW |     |     |       |       |         |
|------------------------------------------------------------------------------------|-----|-----|-------|-------|---------|
|                                                                                    | HRC | HRB | DUR A | DUR D | WEBSTER |
| TYPE OF MATERIAL                                                                   |     |     |       |       |         |
| SIZE OF TEST SAMPLE                                                                |     |     |       |       |         |
| HARDNESS / DUROMETER READING                                                       |     |     |       |       |         |

*testers located in the Quality Office*

| QC 18 INSPECTION                                         | ENGINEERING SIGNOFF (if required)   |
|----------------------------------------------------------|-------------------------------------|
| INSPECTED BY: <u>38 9-89</u><br>DATE: <u>NOV 04 2017</u> | SIGNED OFF BY: _____<br>DATE: _____ |

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



# MATERIAL RECEIPT INSPECTION FORM

## INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER REQUIREMENTS
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
  - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART RELEASED M-DRAWING
- 6- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING & RECORD  
note Aluminum material only

## INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
  - 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
  - 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
  - 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING
- AFTER MATERIAL PASSES INSPECTION**
- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
  - 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

## INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
  - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
  - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
  - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER